

Work Order ID 83432

83432

Page 1

April-18-12 8:15:27 AM

Item ID: D3401-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tow Cap Assembly

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3401

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks 4.20" Long

SA 12/4/25

16

110

0.00

110

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn as per Folio FA532 & Dwg D3401

Folio Rev: _____

Dwg Rev: _____

Deburr

SA 12/4/26

15

1

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 12/4/26

15

1

W/O: 83432		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3401-211 PAR #: _____ Fault Category: Sc Machinery NCR: Yes No DQA: Yes Date: 12/06/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 12/06/07

NCR: 12-1465		WORK ORDER NON-CONFORMANCE (NCR) 133.49						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/4/26	110	- 1 part pulled out of jaws while roughing R.C. Operator error LOA	S as7a12 12/05/22	Scrap - no replace Qty +1	S 12/4/26	S.A 12/05/07	S 12/05/22 as7a12	S 12/05/22

NOTE: Date & initial all entries

Work Order ID 83432

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Setup Start ***NS1***

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Item Name: Tow Cap Assembly

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

Memo

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: ~~13~~ 13

Folio Rev: ~~13~~ 13

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

22 12.5.5

15

0

135

135

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

22 12.5.5

15

0

140

140

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.2 12/05/07

15

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83432

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 18/04/2012 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 02/05/2012 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

0.00

150

Small Fab

000

Small Fab

Memo

Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

W/O: 83432		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3409-041 PAR #: _____ Fault Category: Small FAB. NCR: (Yes) No DQA: ✓ Date: 12/05/30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 12/10/1

NCR: 12-1460		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.05.22	150	C'SINK TOO LARGE ONE PATCH R.C. L&A	<u>GP</u> 12.05.22 <u>PS/4/2</u>	SCRAP. BEARING LOAD FROM TOWING PREVENTS WELD REWORK.	<u>SB</u> 12/05/22	<u>S</u> 12/05/22	<u>GP</u> 12.05.22 <u>PS/4/2</u>	<u>S</u> 12/05/22
			<u>add</u> 12/05/31 <u>PS/4/2</u>				<u>add</u> 12/05/31 <u>PS/4/2</u>	

NOTE: Date & initial all entries

Work Order ID 83432

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Item ID: D3401-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tow Cap Assembly

Stop

NS2

Start Date: 18/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:45
320 °F
3:15

14X ✓

MT
12/05/23

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

14x d M 12/05/25

195

Assemble as per dwg

0.00

195

HandFinish

Memo

0.00

Hand Finishing

14x d M aloske

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83432

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Item ID: D3401-041
Revision ID:
Item Name: Tow Cap Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 16.00 ***16***
Required Date: 02/05/2012 Req'd Qty: 16.00 ***16***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>14</u>	<u>6</u>	<u>12-5-28</u>	
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>FDL</u> Memo	0.00 0.00				<u>210</u>	<u>6</u>	<u>12-5-28</u>	
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>12/5/29</u>	<u>ME</u> <u>12-05-28</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-18-12 8:15:31 AM

Page 1

Work Order ID: 83432

83432

Parent Item: D3401-041

D3401-041

Parent Item Name: Tow Cap Assembly

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A05.09.01 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1330C3KB116		Purchased	No.			100	Each	482.0000	4	64			
NAS1330C3KB116										**	ML 11/05/12		
Insert													

Location

Loc Qty

Loc Code

ST276

482

~~M 11/07/12~~ X22

102606

44

X26

103337

438

X38

M6061T6R3.500

Purchased

No

200

f

12.4000

0.35

5.894737

M6061T6R3.500

**

SL 12/4/12

6061 RD bar 3.50

Location

Loc Qty

Loc Code

MAT036

12.4

119231

0.4

120708

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

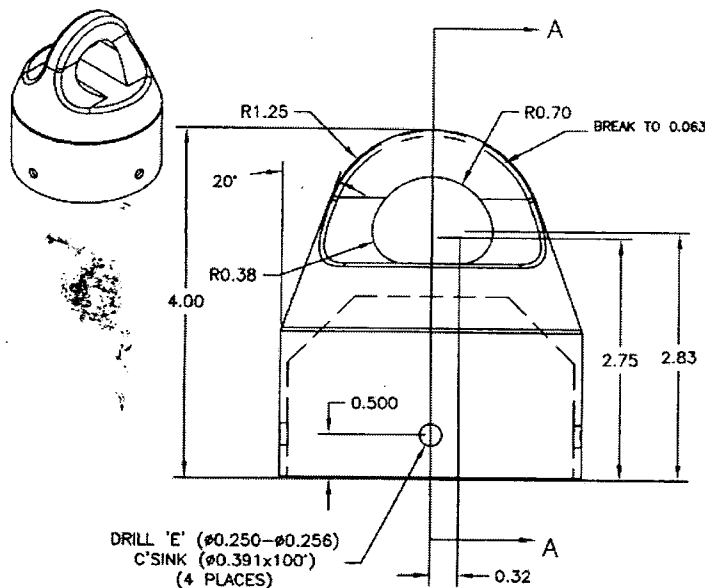
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

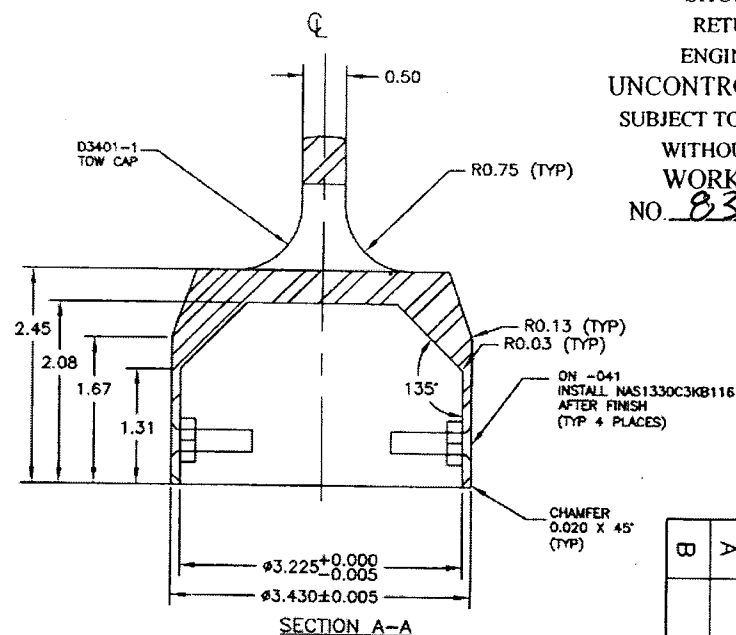
NOTE: Date & initial all entries

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D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 ϕ 3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83432

ML5
12/01/18

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.06.09	TITLE	D3401	SHEET 1 OF 1
			TOW CAP	SCALE 1:2
			CHAMFER INSIDE, REMOVE RADIUS	

RELEASED
05.08.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries